



Dart Aerospace Ltd.
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D3610-041
Job Sheet 212635



Part No: D3610-041

Job Qty: 8 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/20

Job Tracking No:

Due Date: 10/1/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3610 REV B IPP rev A new issue 07.03.28 EC IPP rev B released, changed mat'l EC IPP REV C:AS
PER REV B JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		9/30/20	0.00	0.28	Bandsaw - 1	52 9-89	20/10/02
110	HAAS 4 Axis - B4B	8 pcs		9/30/20	0.39	10.39	HAAS - 1 - B4B HAAS - 2 - B4B HAAS - 3 - B4B HAAS - 4 - B4B		DJP 20-10-04
120	QC 2	8		9/30/20	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62		



Container No: S304689



Part: D3610-041

Job No: 212635

Serial No/Batch: S304689

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/08/20

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130 QC 8	8 pcs	9/30/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
140 Small Fab - 2 - B4B	8 pcs	9/30/20	0.00 0.33	QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	8 pcs	9/30/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

DJP 20-10-04

JF 20-10-04

OCT 05 2020

						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	OCT 05 2020
						QC 5 - 61	DAS 40 9-89
						QC 5 - 81	
						QC 5 - 82	
160	Powdercoat - 3 Grey Sand - B4B	8 pcs	9/30/20	0.00 1.67	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
					Powdercoat - 5 - B4B		
					Powdercoat - 6 - B4B		
					Powdercoat - 7 - B4B		
					Powdercoat - 8 - B4B		
					Powdercoat - 9 - B4B		
					Powdercoat - 10 - B4B		
170	QC 3	8 pcs	9/30/20	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
					QC 3 - 87		
					QC 3 - 47		
180	Small Fab - 3 - B4B	8 pcs	10/1/20	0.00 0.33	Small Fab - 1 - B4B		
					Small Fab - 2 - B4B		
					Small Fab - 3 - B4B		
					Small Fab - 4 - B4B		
					Small Fab - 5 - B4B		
					Small Fab - 6 - B4B		
					Small Fab - 7 - B4B		
					Small Fab - 8 - B4B		
					Small Fab - 9 - B4B		

				Small Fab - Various 1 - B4B		
190 QC 5	8 pcs	10/1/20	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
				QC 5 - 82		
					DAS 82 9-89 OCT 07 2020	
200 Packaging 3-1 - Stock - B4B	8 pcs	10/1/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
					DAS 20 9-89 OCT 08 2020	
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210 QC 21 - SA	8 pcs	10/1/20	0.00 0.00	QC 21 - SA - 21	DAS 28 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - (Bandsaw) Cut blank 7.900 " long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: B 2-Deburr per dwg D3610
 120 - QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) 1-C'SINK AS PER DWG D3610
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Rivet Nut Plate as per Dwg D3610
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140N-B1.500X1.5000	4140 Steel Bar 1.50 X 1.50	5.2000 ft (.65 ea)	100-Bandsaw - 1	5301429
MS20426AD3-4	Rivet	16 Ea (2 ea)	180-Small Fab - 3 - B4B	57136444 2.
MS21075L3	Nut Plate	8 Ea (1 ea)	180-Small Fab - 3 - B4B	5303863

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M4140N-B1.500X1.5000	5	2	0
180-Small Fab - 3 - B4B	MS20426AD3-4	16	317	0
	MS21075L3	8	31	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 212635
Description: Plate		Part Number: D3610-1
Inspection Dwg: D3610 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.245	✓		Vern.	B18193523
0.250	+/-0.010	0.250	✓		Vern.	"
0.63	+/-0.030	0.623	✓		Vern.	"
7.75	+/-0.030	7.751	✓		H.G.	REF
4.25	+/-0.030	4.250	✓		H.G.	"
2.677	+/-0.010	2.677	✓		Vern.	B18193523
0.38	+/-0.030	0.375	✓		Vern.	"
Ø0.277	+0.006/-0.001	0.278	✓		Vern.	"
Ø0.201	+0.005/-0.001	0.201	✓		G.P.	REF
Ø0.098	+0.004/-0.001	0.0995	✓		G.P.	"
0.88	+/-0.030	0.880	✓		H.G.	"
0.94 x 0.50	+/-0.030	0.938 x 0.503	✓		Vern.	B18193523
0.250	+/-0.010	0.251	✓		Vern.	"
0.125 depth	+/-0.010	0.128	✓		Dept. Gage	896011

Measured by: JJP	Audited by: DAS 20 9-89	Preliminary Approval:
Date: 20-10-03	Date: 20-10-04	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>212635</u> Part No. <u>D3610-041</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : <u>OCT 16 2020</u>		Sequence #: <u>160 - Powdercoat</u>		QTY Affected : <u>8 PCS-</u>		MRB (QSI042) <u>DAS</u> <u>9</u> <u>9-89</u> <u>20-10-6</u>			
Description Work Order Deviation <u>Nutplate installed prior to painting.</u> <u>Remove nutplate & rivets, c/sink</u> <u>per dwg then paint.</u> <u>Return to smallfab for</u> <u>assembly of rivets/nutplate.</u>				Disposition <u>Acceptable</u> <u>MS20426AD3-4 x 16 : S</u> <u>MS21075L3 x 8 : S</u>				Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☒ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							